

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010196**Date Inspected:** 10-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chan Ying Xin**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower COMPONENT**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Bay #10

This QA Inspector observed the following work in progress:

SMAW welding in the 2G position at weld joint ED1-A6001-3-10B located on East Tower Strut assembly .

Welder is identified as #053049.ZPMC QC is identified as Mr. Yuan Hui Gang.The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1 .

SMAW welding in the 2G position at weld joint ED1-A6001-3-8A located on East Tower Strut assembly .

Welder is identified as #040582.ZPMC QC is identified as Mr. Yuan Hui Gang.The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1 .

SMAW welding in the 2G position at weld joint ED1-A6001-3-10B located on East Tower Strut assembly .

Welder is identified as #050289.ZPMC QC is identified as Mr. Yuan Hui Gang.The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1 .

SMAW welding in the 2G position at weld joint ED1-A6003-8-8A located on East Tower Strut assembly .

Welder is identified as #052930.ZPMC QC is identified as Mr. Yuan Hui Gang.The welding variables recorded by

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QC appeared to comply with WPS-B-T-3212-Tc-U5b-1 .

SMAW welding in the 2G position at weld joint ED1-A6003-7-7B located on East Tower Strut assembly . Welder is identified as #056200.ZPMC QC is identified as Mr. Yuan Hui Gang.The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1 .

SMAW welding in the 2G position at weld joint ED1-A6003-7-9A located on East Tower Strut assembly . Welder is identified as #040333.ZPMC QC is identified as Mr. Yuan Hui Gang.The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1 .

FCAW in the 2G position of the South Tower Diaphragm to Skin Plate 'C' weld No. NSD1-SPSA3-70-2A. The welder is identified as #040261. ZPMC QC is identified as Mr. Li Ming .The welding variables recorded by QC appear to comply with WPS-B-T-4332-Tc-P5-F.

FCAW in the 2G position of the South Tower Diaphragm to Skin Plate 'C' weld No. NSD1-SPSA3-70-2A. The welder is identified as #040261. ZPMC QC is identified as Mr. Li Ming .The welding variables recorded by QC appear to comply with WPS-B-T-4332-Tc-P5-F.

FCAW in the 2G position of the South Tower Diaphragm to Skin Plate 'C' weld No. NSD1-SPSA3-70-2A. The welder is identified as #040261. ZPMC QC is identified as Mr. Li Ming .The welding variables recorded by QC appear to comply with WPS-B-T-4332-Tc-P5-F.

Ultrasonic Testing (UT)

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as Tower Shear plate welds .

The Weld Designations are as follow

NSD1-A112A/H-1A/B

Bay#10 Struts Repair.

During the visual inspection the QA Inspector observed the ZPMC personal gouged the repair area on Tower strut , weld Identified as ND1-A6002-1-7B and ND1-A6002-4-9B.

For details see attached picture for details.

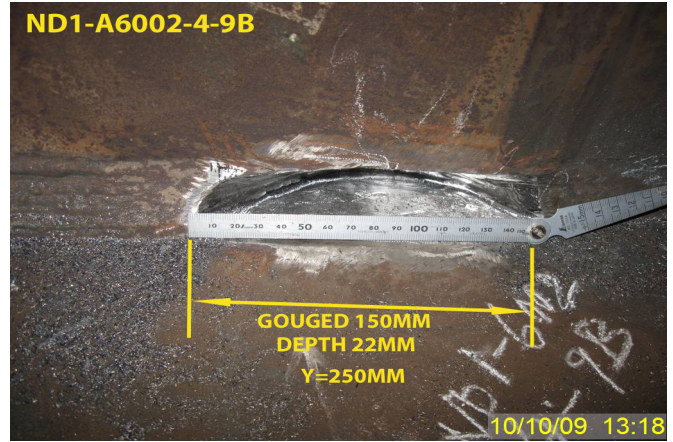
Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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## Summary of Conversations:

No relevant conversations

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 13482570045, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Bera,Subhasis	Quality Assurance Inspector
<b>Reviewed By:</b>	Patterson,Rodney	QA Reviewer

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